

Work Order ID 89687

August-30-12 12:52:49 PM

89687

Page 1

Item ID: DSK076

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: D2891-1 TURNING DETAIL

Start Date: 30/08/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 13/09/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/08/30 Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSK076

Rev A

100

0.00

100

DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

Turn blank for as per Folio FA046
DT8671

5/

129070

10 φ

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

5/

129030

10 φ

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

DA
14
2-89

12/10/04

10 φ

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
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Operator <input type="checkbox"/>																											
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Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											
FAULT CATEGORY																											
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Page 2

Item ID: DSK076

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: D2891-1 TURNING DETAIL

Start Date: 30/08/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 13/09/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: MAT060

12/10/04

10

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/10/04

W12.10.04

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

August-30-12 12:52:53 PM

Page 1

Work Order ID: 89687

89687

Parent Item: DSK076

DSK076

Parent Item Name: D2891-1 TURNING DETAIL

Start Date: 30/08/2012

Required Date: 13/09/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6104-003

Manufactured

No

Each

6.0000

10

D6104-003

**

Round Billet, 17-4

Location

Loc Qty

Loc Code

MAT043

6

60943

3

81882

3

89822

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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DART AEROSPACE LTD		Work Order:	89687
Description: Turning Detail for D2891-1		Part Number:	DSK076
Inspection Dwg: DSK076	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.274	2.279		2.277	2.277	2.277	2.277	2.276
B	3.702	3.722		3.715	3.714	3.715	3.714	3.714
C	2.564	2.584		2.572	2.572	2.572	2.572	2.572
D	0.718	0.738		.725	.725	.725	.725	.725
E	0.090	0.110		.101	.101	.101	.101	.101
F	2.464	2.484		2.472	2.472	2.472	2.473	2.473
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	2.964	2.984		2.973	2.973	2.973	2.973	2.973
I	0.913	0.933		.925	.925	.925	.925	.925
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.075	.074	.075	.073	.073
L								
M								
N								
O								
P								

Measured by:	Date:
Audited by:	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

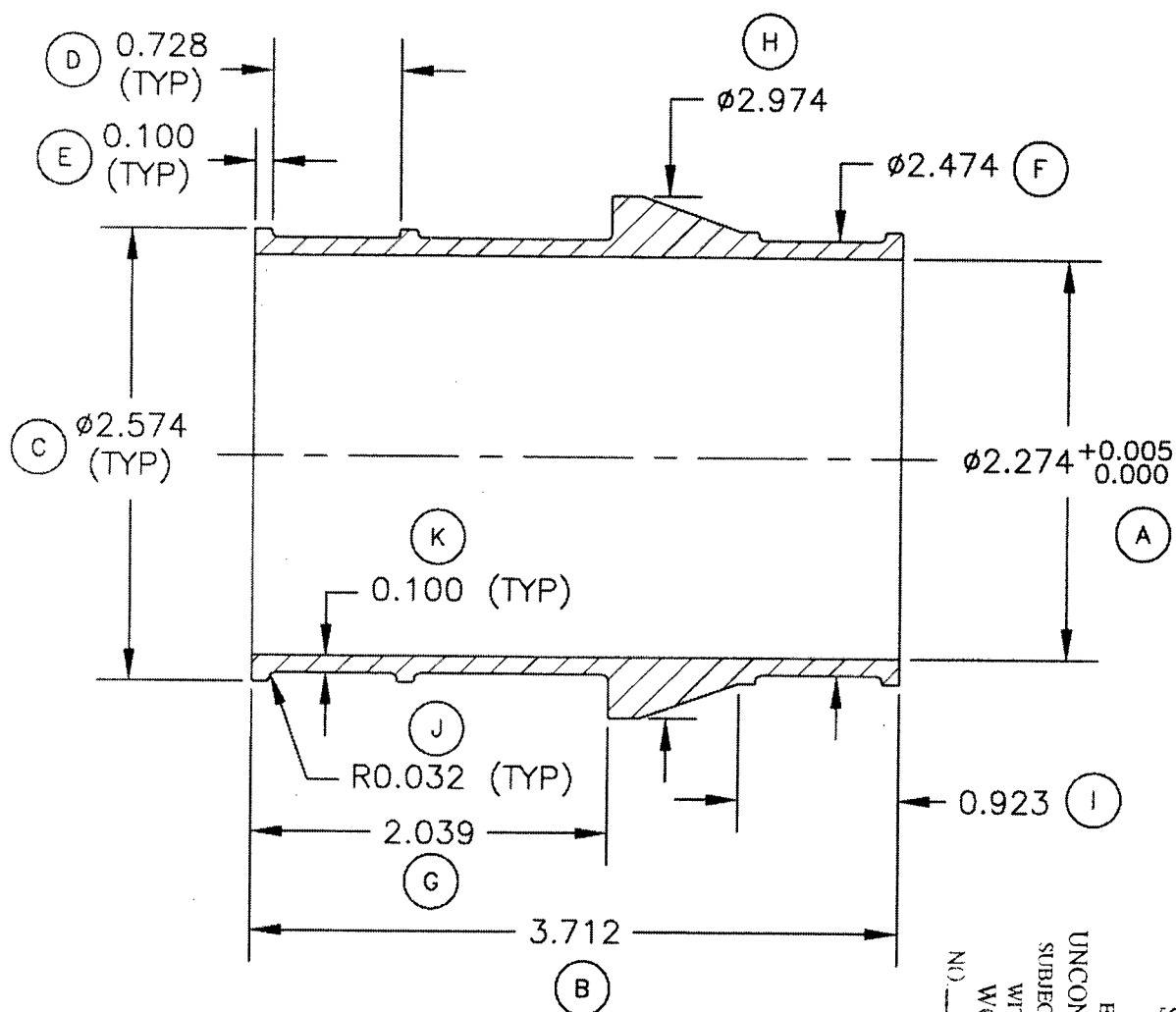
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION <div style="display: flex; justify-content: space-around;"> <div> <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update </div> <div> <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab </div> <div> <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite </div> <div> <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier </div> <div> <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other </div> </div>							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
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DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CH	APPROVED CH	DRAWING NO. DSK 076	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2891-1	SCALE 1:1
A	03.05.20	NEW ISSUE	



D2891-1 TURNING DETAIL

12/08/10
NO. 29687-11-5
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
REPRINT TO
SHIP COPY

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NCR: Yes / No

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D	0.718	0.738		.728	.728	.728	.728	.728
E	0.090	0.110		.100	.101	.101	.100	.101
F	2.464	2.484		2.472	2.473	2.472	2.472	2.473
G	2.029	2.049		2.040	2.040	2.040	2.040	2.040
H	2.964	2.984		2.972	2.972	2.972	2.972	2.973
I	0.913	0.933		.925	.925	.925	.925	.925
J	0.022	0.042		.031	.031	.031	.031	.031
K	0.090	0.110		.094	.093	.093	.094	.094
L								
M								
N								
O								
P								

Measured by:	Date: 12/10/11
Audited by: DAS 14 2-89	Date: 12/10/09
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	